Work Order ID 110032

110032

December-17-13 9:06:37 AM

Item ID: D2858-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Hinge Bracket

Start Date: 12/17/13 **Start Qty:** 12.00 *12*
Required Date: 12/17/13 **Req'd Qty:** 12.00 *12*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** M **Date:** 13-12-14 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D2858 / Rev C									
100	BAND SAW	0.00	DX			4 blanks	ϕ		
100		0.00	13-12-30						
Bandsaw	**Memo**								
Jeaspa Bandsaw	Cut blanks 5.850 " Note: 1 Blank Makes 3 Parts								
110	HAAS CNC VERTICAL MACHINING #1	0.00				12	ϕ		DAS 08 9-89
110		0.00	D.A	13/01/02					
HAAS 1	**Memo**								
HAAS CNC vertical machine #1	1-Machine per folio FA941 FOLIO REV: AA DWG REV: C 2-Deburr any rough edges								
120	QC2- Inspect parts off machine FAI/FAIB	0.00	D.A	14/01/02		12	ϕ		DAS 08 9-89
120		0.00							
QC	**Memo**								
Quality Control									

Item ID: D2858-1 **Accept** *N900040100* **Setup Start** *NS1*
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Item Name: Hinge Bracket

Start Date: 12/17/13 **Start Qty:** 12.00 *12* **Cust Item ID:**
Required Date: 12/17/13 **Req'd Qty:** 12.00 *12* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				12	0		DAS 40 9-89
130									14/01/02
QC	**Memo**	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				12	0	14-1-3	
140									
HandFinish	**Memo**	0.00							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				12	0	14-1-7.	DAS 34 9-89
150	M 126809.								
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 12:50 OVEN TEMPERATURE: 320 FINISH TIME: 1:20								

Item ID: D2858-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Hinge Bracket
Start Date: 12/17/13 **Start Qty:** 12.00 *12* **Cust Item ID:**
Required Date: 12/17/13 **Req'd Qty:** 12.00 *12* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00 DAS 27 9-89				12			
160 QC Quality Control	**Memo**	0.00 12/17							
170	Identify as per dwg & Stock Location: STO/9	0.00							DAS 26 9-89
170 Packaging Packaging	**Memo**	0.00				12x		14-1-8	
180	QC21- Final Inspection - Work Order Release	0.00							
180 QC Quality Control	**Memo**	0.00					14-01-8		

08/01/2014 14-01-8

Picklist Print

December-17-13 9:06:36 AM

Work Order ID: 110032

Parent Item: D2858-1 **Start Date:** 12/17/13 **Required Date:** 12/17/13

Parent Item Name: Hinge Bracket **Start Qty:** 12.00 **Required Qty:** 12.00

Comments: IPP C00.06.22Removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.250 6061-T6 Bar 1.50 x 1.25		Purchased	No			100	f	28.0000	**0.163**	**2.0589468**	AP 13-12-30		

Location	Loc Qty	Loc Code
MAT003	27.9999859	
124443	3.9999859	
m127454	24	

2.058

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

DART AEROSPACE LTD	Work Order:	110032
Description: Hinge Bracket	Part Number:	D2858-1
Inspection Dwg: D2858 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

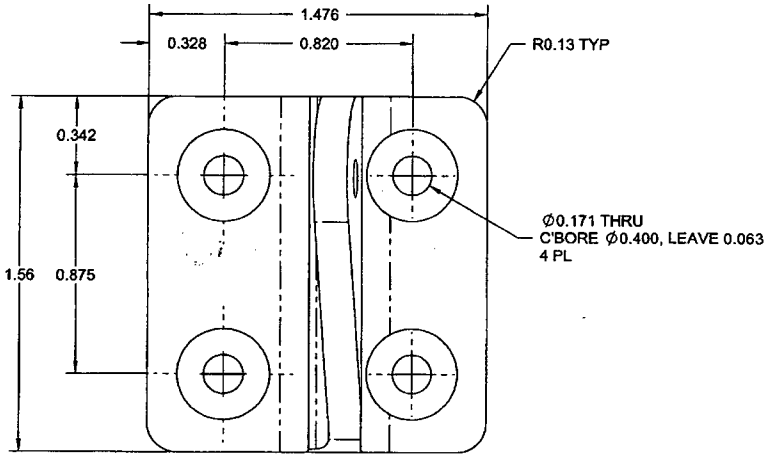
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.001	ϕ 0.176	✓		Vern	GA-01
Ø0.400	+0.006/-0.001	ϕ 0.402	✓		"	"
R0.125	+/-0.010	R 0.125	✓		R-6	ref.
0.328	+/-0.010	0.328	✓		Vern	GA-01
0.820	+/-0.005	0.820	✓		"	"
1.476	+/-0.010	1.476	✓		"	"
0.342	+/-0.010	0.342	✓		"	"
0.875	+/-0.005	0.875	✓		"	"
1.56	+/-0.030	1.565	✓		"	"
0.147	+/-0.010	0.147	✓		Mic	GA-03
0.717	+/-0.010	0.727	✓		H-6	31006
0.697	+/-0.010	0.695	✓		"	"
0.229	+/-0.010	0.230	✓		Vern	GA-01
R0.125	+/-0.010	R0.125	✓		R-6	ref.
R0.063	+/-0.010	R0.063	✓		"	"
0.063	+/-0.010	0.062	✓		Vern/Mic	GA-03
0.126	+/-0.010	0.127	✓		"	"
0.630	+/-0.010	0.631	✓		Dial ind	HAAS-4
R0.354	+/-0.010	R0.354	✓		R-6	ref.
0.965	+/-0.010	0.969	✓		Vern	GA-01
Ø0.166	+0.005/-0.001	ϕ 0.167	✓		"	"
R0.125	+/-0.010	R0.125	✓		R-6	ref.
32.7°	+/-0.5°	32.7°	✓		Angle n.	CNC-03

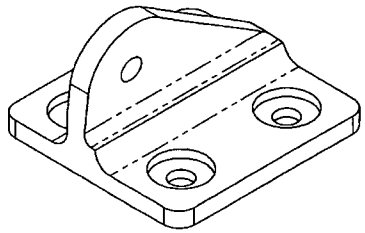
Measured by:	N.a DAS 08 9-89
Date:	13/01/02

Audited by:	DAS 40 9-89
Date:	14/01/02

Preliminary Approval:	
Date:	

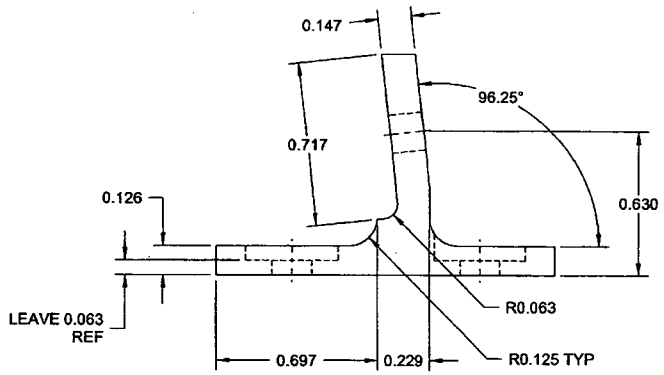
Rev	Date	Change	Revised by	Approved
A	07.10.30	New Issue	KJ/EC/DD	
B	11.11.07	Dwg Rev updated	KJ	

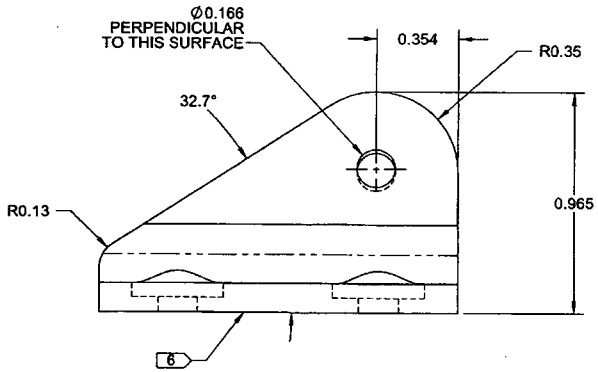




110032

M 13-12-17





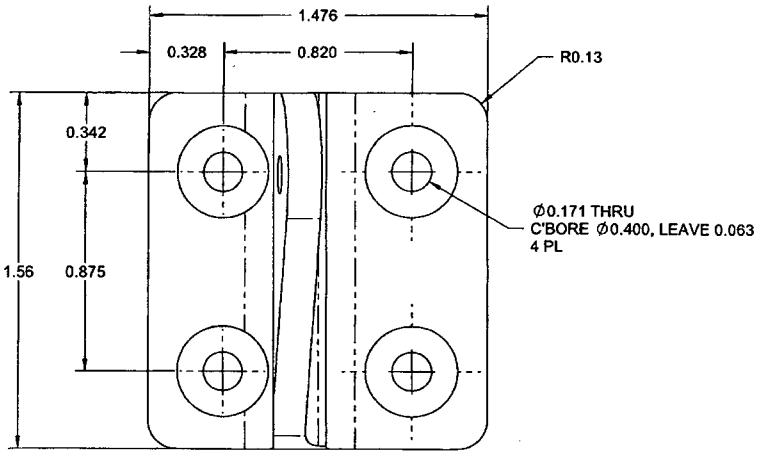
RELEASED
2010 -11- 26

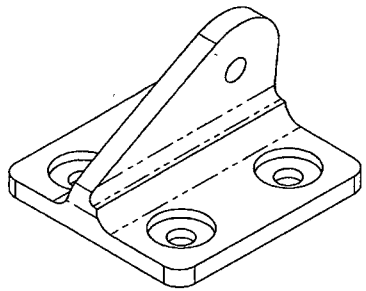
D2858-1 HINGE BRACKET

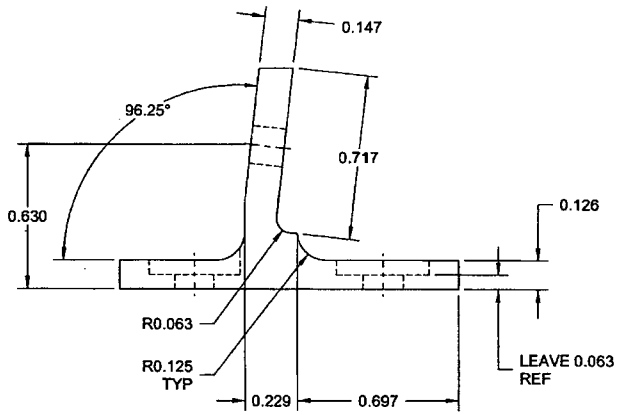
NOTES:
1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
△C 6) IDENTIFICATION: DART P/N "D2858-1" PER DART QSI 044 6.1
7) WEIGHT: 0.04 lbs

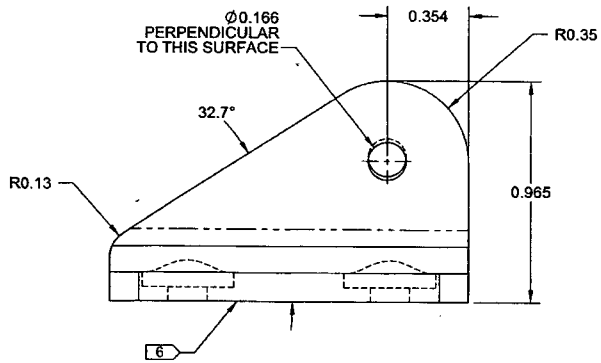
REV.	DESCRIPTION	BY	DATE
C	REDRAW TO CURRENT STD, REMOVE ENGRAVED P/N, IDENT. NOW W/ MARKER (A8-1,A8-2), REF PAR 10-040	CP	10.10.12
B	0.717 WAS 0.667, 1.56 WAS 1.559	KE	99.02.28
A	NEW ISSUE	KE	98.12.14

DESIGN	KE	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D2858 REV. C
MFG. APPR.		SHEET 1 OF 2
APPROVED		TITLE HINGE BRACKET
DE APPR.		SCALE NTS
DATE	10.10.12	









RELEASED
2010-11-26

D2858-2 HINGE BRACKET

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
△C 6) IDENTIFICATION: DART P/N "D2858-2" PER DART QSI 044 6.1
7) WEIGHT: 0.04 lbs

DESIGN	KE	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D2858 REV. C
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE HINGE BRACKET SCALE NTS
DE APPR.		
DATE	10.10.12	